

# Work Order ID 80321

Thursday, February 16, 2012 2:35:01 PM

**\*80321\***

Page 1

Item ID: D2616-2

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Mounting Lug, EC 120 Step

Start Date: 2/16/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 3/1/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 12-02-16

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2616

Rev E

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 2.000" long +0.030" -0.000"

*OK 12/02/19*

*5*

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

I-Machine as per folio D2616-2 & DWG D2616 2-Tumble & Deburr

*R R-2-21*

*5*

120

0.00

**\*120\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*22 R-2-21*

*5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

B.A 12/02/22

5 0

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

5 2P/M/Feb 22/2012

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

Note:Mask large hole

TEMPERATURE:

FINISH TIME:

OVEN

3250F

10:30

10:00

5X/M-F 12/02/27

M118489

**Dart Aerospace Ltd**

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Start Date: 2/16/2012 Start Qty: 5.00

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Cust Item ID:

Required Date: 3/1/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Small Fab

0.00

**\*170\***

Small Fab

Memo

0.00

Small Fab

1-Coat bearing in light oil2-Press Bearing in D2616-23-Stack as per Dwg  
D2616 using DT8019 4- Touch up paint if required

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

ES 12/02/27 (5)

ES 12/02/27 (5)

(5)

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Required Date: 3/1/2012 Req'd Qty: 5.00

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Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: 012

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

12/2/27 *[Signature]*  
ME  
12-02-27

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, February 16, 2012 2:35:00 PM

Page 1

Work Order ID: 80321  
 Parent Item: D2616-2  
 Parent Item Name: Mounting Lug, EC 120 Step

Start Date: 2/16/2012  
 Start Qty: 5.00  
 Required Date: 3/1/2012  
 Required Qty: 5.00

Comments: IPP Rev:C00.06.22Removed P/O for powder coatEC  
 IPP Rev:D 08-01-07 rev E as per dwg ECN1069 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.000 6061-T6 Bar 1.00 x 2.00		Purchased	No			119007	f	72.1260		0.83			

Location	Loc Qty	Loc Code
MAT003	23.646	
112567	16.6	
118106	7.046	
MAT004	48.48	
120044	0.48	
120603	48	

D2611 x 1 per kit  
 B# 77485  
 MF  
 1202-27

M119007 x .87 ok 12/02/19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 80321
<b>Description:</b> Mounting Lug		<b>Part Number:</b> D2616-2
<b>Inspection Dwg:</b> D2616	<b>Rev:</b> D3	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.252	/		P.02	
1.250	+/-0.010	1.250	/			
0.375	+/-0.010	.376	/			
0.625	+/-0.010	.620	/			
Ø0.257	+0.006/-0.001	.257	/			
1.000	+/-0.010	1.002	/			
2.000	+/-0.010	2.009	/			
1.125	+/-0.010	1.125	/			
0.313	+/-0.010	.315	/			
17°	+/-0.5°	17°	/			
1.259	+/-0.010	1.259	/			
<del>Ø0.625</del>	<del>±0.008/0.001</del>					
R0.250	+/-0.010	R.25	/			
R0.063	+/-0.010	R.063	/			
Ø0.8115- Ø0.8120	N/A	.8115	/			

<b>Measured by:</b> [Signature]	<b>Audited by:</b> B.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12.2.21	<b>Date:</b> 12/02/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM [Signature]	[Signature]

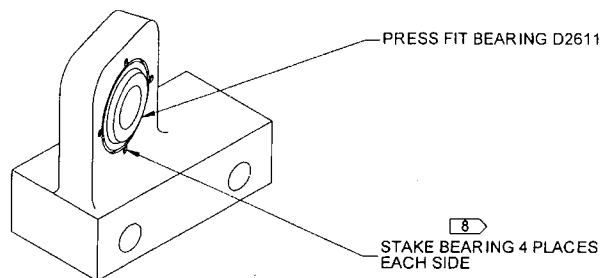
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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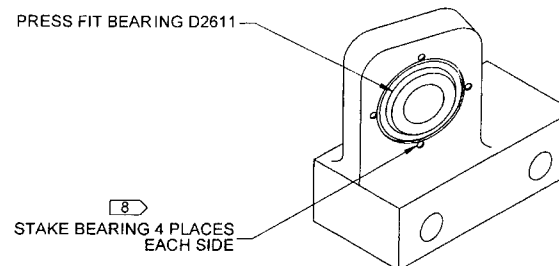
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NOTE: Date & initial all entries



**D2616-1 FWD MOUNT LUG**



**D2616-2 FWD MOUNT LUG**

#80321

RELEASED  
07.12.12

QTY -1	QTY -2	PART NUMBER	DESCRIPTION
X		D2616-1	FWD MOUNT LUG
	X	D2616-2	FWD MOUNT LUG
1	1	D2611	BEARING
1		D2616-1A	LUG
	1	D2616-2A	LUG

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019. TOUCH UP PAINT AFTER STAKING.

E	UPDATE DWG: SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES	DC	07.11.22
D	D2611 WAS C8A-6-B2	KE	97.07.31
C	REMOVE D2616-3	BW	97.06.04
B	RE-DESIGN	KE	97.05.06
A	ORIGINAL ISSUE	BW	96.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2616	SHEET 1 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	FWD MOUNT LUG	1:1
DATE	07.11.22	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD  THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

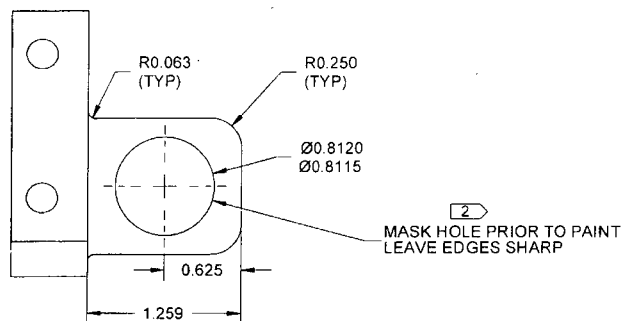
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

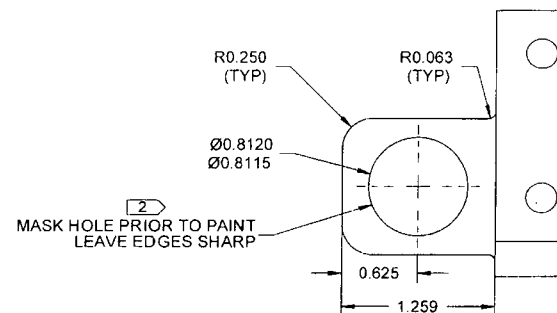
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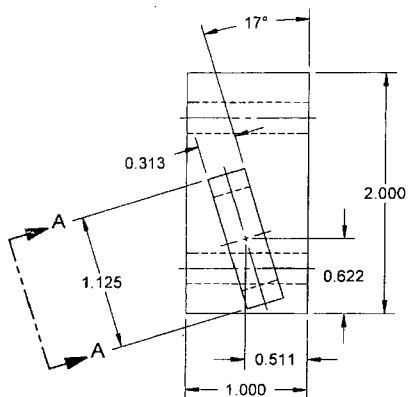
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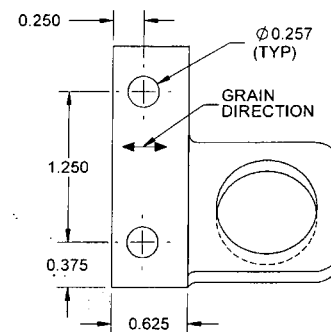
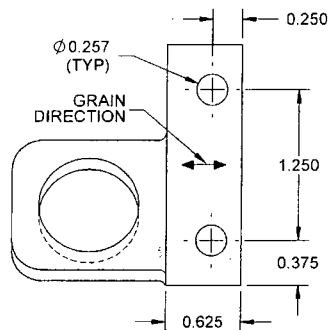
VIEW A-A



VIEW B-B



D2616-1A LUG



D2616-2A LUG

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
MASK BEARING HOLE PRIOR TO PAINT  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED  
07-12-12

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LC		
CHECKED	LE	DRAWING NO. D2616	REV. E
MFG. APPR.	AD	SHEET 2 OF 2	
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	FWD MOUNT LUG	1:1
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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